

Work Order ID 69556 -2

Thursday, May 12, 2011 8:25:04 AM

Page 1

Item ID: D3290-3

Revision ID:

Item Name: Window

Start Date: 5/12/2011 Start Qty: 16.00

Required Date: 5/17/2011 Req'd Qty: 16.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

0.00

0.00

0.00

0.00

0.00

0.00

FLOW WATER JET

Memo

1-Cut as per Dwg D3290 1 Dwg Rev: 2-
Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

QC8- Inspect parts - second check

Memo

100



Waterjet

FLOW CNC Waterjet

110



QC

Quality Control

120



QC

Quality Control



131-5-12

131-5-12

131-5-12

131-5-12

split - 2

14

18

18

Work Order ID 69556

Thursday, May 12, 2011 8:25:04 AM



Page 2

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 5/12/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

x18

Thermoforming Machine

Without removing protective skin/ remove sharp edge by degurring.

DL
11/05/13

140

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

x17

x1

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg.
Rev. C Folio Rev. B 12-Engrave part# &
batch# (D3290-3)

DL
11/05/13
P70 →

150

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

x17

Quality Control

DL
11/05/13

Work Order ID 69556

Thursday, May 12, 2011 8:25:04 AM



Item ID: D3290-3

Revision ID:

Item Name: Window

Start Date: 5/12/2011 Start Qty: 16.00

Required Date: 5/17/2011 Req'd Qty: 16.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Run Start

Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

0.00

Memo

Water sand and buff to remove scratches if required

x17.

11/05/13

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/10/13

47

190



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Memo

6x W.O 72197

11/09/12

Work Order ID 69556

Thursday, May 12, 2011 8:25:04 AM



Page 4

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 5/12/2011 Start Qty: 16.00



Required Date: 5/17/2011 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/22 JF

MF

11-09-12

Picklist Print

Thursday, May 12, 2011 8:25:01 AM

Page 1

Work Order ID: 69556

Parent Item: D3290-3

Parent Item Name: Window



Start Date: 5/12/2011

Required Date: 5/17/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP A 04.08.18 New issue KJ/RF
 IPP B 06.05.09 Ecn 798 EC
 C Removed QC8 Step 160 11/04/11 DL
 IPP C 07.05.29 Thermoform in-house DL
 IPP D 07.09.28 rev C dwg EC verified by: DD
 IPP E 07.11.28 Add --Hand finish deburring DL

IPP Rev.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			100	sf	352.9934	3	50.52632	64		



B11-5-12

Location

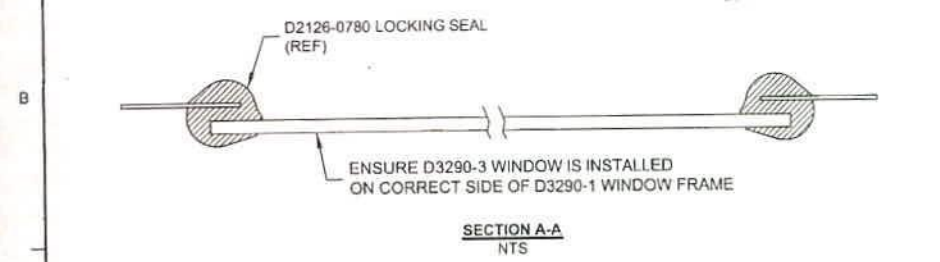
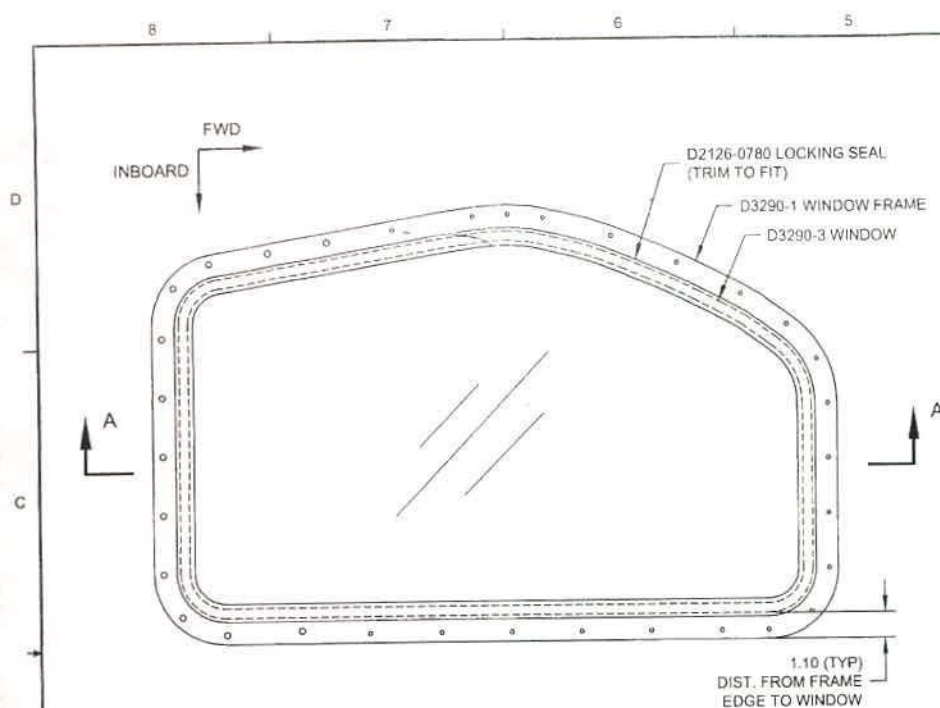
Loc Qty

Loc Code

MAT 206.2467
 117431 206.2467
 MAT018 142.2467
 117324 68.7667
 117340 73.48
 MAT019 4.5
 115338 4.5

117431

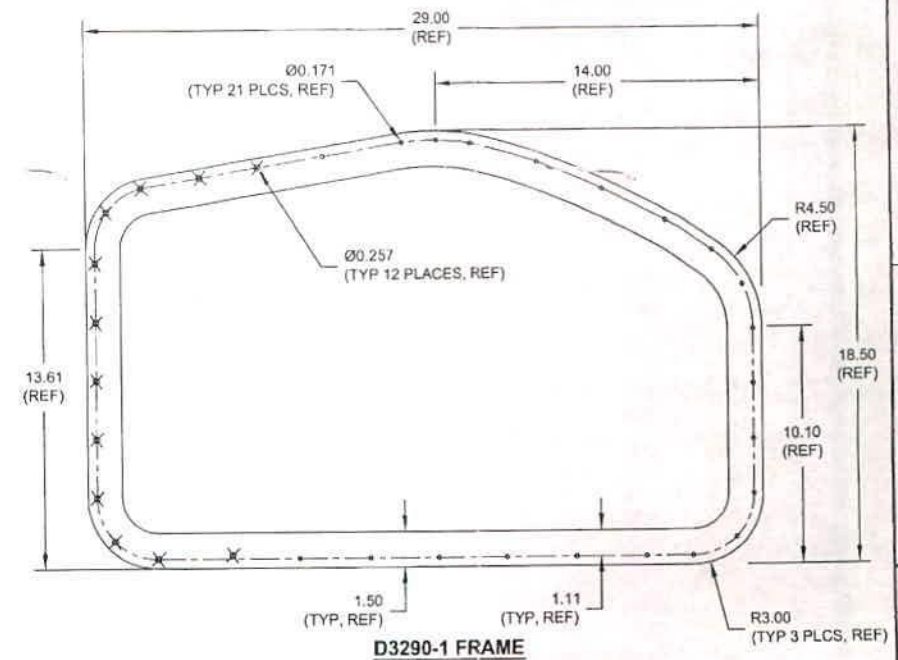
(18)



D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED



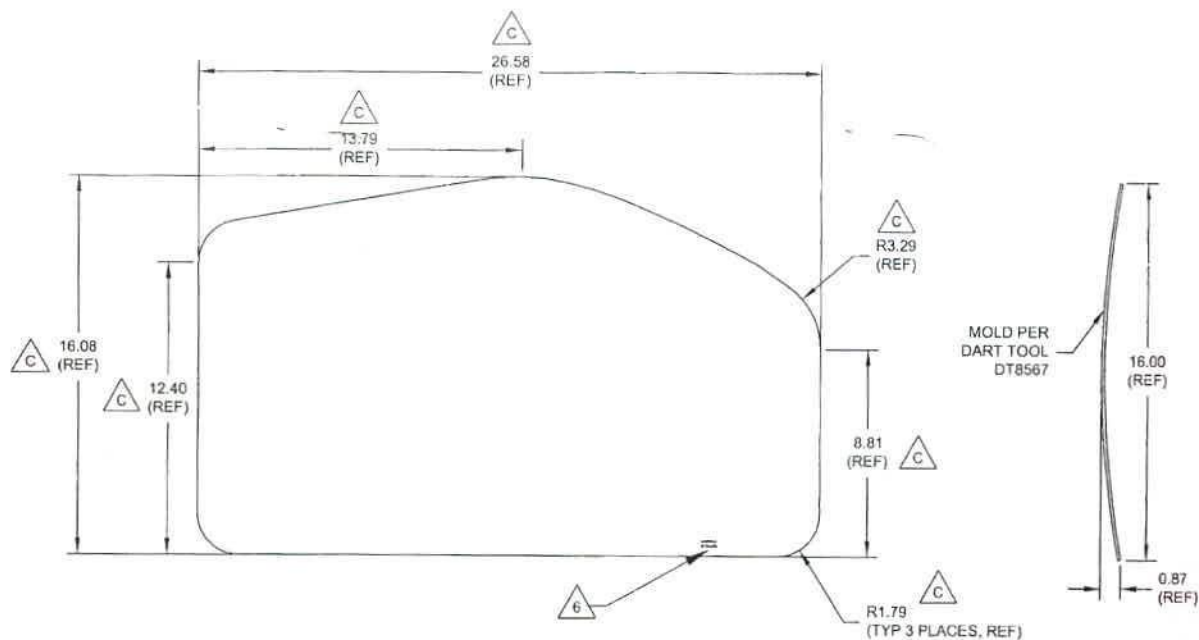
- D3290-1 NOTES:**
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.47 LBS

RELEASED
07.07.24
DEO ATTACHED

UNDER REVIEW

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3290
REV. C
SHEET 1 OF 2
TITLE REPLACEMENT WINDOW ASSEMBLY
SCALE 1:5
COPYRIGHT © 2004 BY DART AEROSPACE LTD
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR REPRODUCTION IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED
RELEASED
07.07.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>h</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>WJ</i>	DE APPR. <i>WJ</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09

WJ
69/56

COPYRIGHT © 2009 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.